



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D212-664-207
Job Sheet 195637



Rework

Part No: D212-664-207

Job Qty: 1 pcs

Part Name: Aft Crosstube - Low Standard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/28/19

Job Tracking No:

Due Date: 6/5/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D/ IIN-D212-664 REV.J IPP Rev:A New Issue 07.09.12 EC verified by: JLM IPP Rev:B ECN 1100p 08-01-11 DD verified by: EC IPP Rev:C ECN 1121 08-02-25 DD verified by:eC IPP Rev: D QC5 replaced by QC15 at step 5 KJ Verified by: ec

Ship Via:

Chg#4
DAS
35
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		6/5/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		<i>AB 19-5-29</i>
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Plex 5/28/19 11:40 AM dart.lacelle.linda



Container No: S184886



Part: D212 - 664 - 207

Job No: 195637

Serial No/Batch: S184886

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

D212-664-207 / 018 155965/195637/5184886

210	Crosstubes - 4 - B4B	1 pcs	6/5/19	0.00 2.00	Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	AR 19-5-29
					Crosstubes - 1 - B4B	
215	QC 5	1 pcs	6/5/19	0.00 0.00	Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	AR 19-5-29
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	DAS
					QC 5 - 3	19
					QC 5 - 43	9-05
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
220	Spray Paint - 2 - B4B	1 pcs	6/5/19	0.00 0.33	Spray Paint - 1 - B4B	AR 19-5-20
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
230	QC 14	1 pcs	6/5/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	AR 19-6-1
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
240	Crosstubes - 5 - B4B	1 pcs	6/5/19	0.00 2.00	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	AR 19-6-1
250	QC 5	1 pcs	6/5/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	

				QC 5 - 58		
				QC 5 - 68		DAS JUN 03 2019 68
				QC 5 - 9		9-89
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
255 Packaging 1-1 - Pick Kit - B4B	1 pcs	6/5/19	0.00 0.00	Packaging 1 - 1 - B4B		
				Packaging 1 - 2 - B4B		
				Packaging 1 - 3 - B4B		
				Packaging 1 - 4 - B4B		
				Packaging 1 - 5 - B4B		DAS 28 9-89
				Packaging 1 - 6 - B4B		
				Packaging 1 - 7 - B4B		
				Packaging 1 - 8 - B4B		
				Packaging 1 - 9 - B4B		
				Packaging 1 - 10 - B4B		
				Packaging 1 - 11 - B4B		
				Packaging 1 - 12 - B4B		
				Packaging 1 - 13 - B4B		
				Packaging 1 - 14 - B4B		
				Packaging 1 - 15 - B4B		
				Packaging 1 - 16 - B4B		
				Packaging 1 - 17 - B4B		
				Packaging 1 - 18 - B4B		
				Packaging 1 - 19 - B4B		
				Packaging 1 - 20 - B4B		
				Packaging 1 - 21 - B4B		
				Packaging 1 - 22 - B4B		
				Packaging 1 - 23 - B4B		
				Packaging 1 - 24 - B4B		
				Packaging 1 - 25 - B4B		
				Packaging 1 - 26 - B4B		
				Packaging 1 - 27 - B4B		
				Packaging 1 - 28 - B4B		
				Packaging 1 - 29 - B4B		
				Packaging 1 - 30 - B4B		
				Packaging 1 - 31 - B4B		
				Packaging 1 - 32 - B4B		
				Packaging 1 - 33 - B4B		
				Packaging 1 - 34 - B4B		
				Packaging 1 - 35 - B4B		
				Packaging 1 - 36 - B4B		
260 QC 4	1 pcs	6/5/19	0.00 0.00	QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		DAS 75 9-89
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		08/10/2019
				QC 4 - 74		
270 Packaging 3-1 - Stock - B4B	1 pcs	6/5/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		DAS 75 9-89
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		08/10/2019
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		

					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275	DC - 1 - B4B	1 pcs	6/5/19	0.00 0.00	DC - 1 - B4B	DAS 21
					DC - 2 - B4B	9-89
280	QC 21 - FG	1 pcs	6/5/19	0.00 0.00	QC 21 - FG - 21	DAS 21
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-89

AUG 12 2019

AUG 12 2019

Part Op 110 - PICK KIT

Descriptions: **210** - Crosstubes *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Rivet and assemble Cuffs with T-Pin in the through bolt holes as per Dwg D212-664-247. with Sika flex in Between tube & Cuff

215 - QC5- Inspect part completeness to step on W/O *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***
Inspect cuff with T-Pin

220 - Spray Paint / NDT Room *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** clear: 5151467
PRIMER: 5154137 START TIME: FINISH TIME: PAINT: 3184740

230 - QC14- Inspect Spray Paint - Wrap in plastic bag to protect from scratches

240 - Crosstubes - 1- Assemble as per Dwg D212-664-247 2- Install supports with Proseal 890 per D212-664-247 and QSI 015 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) as per Dwg D212-664-247.

250 - QC5- Inspect part completeness to step on W/O - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

255 - Pick Kit

260 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O

270 - Identify as per dwg & Stock Location: FG098 Identify and pack for shipping as per PPP D212-664-207

275 - Document Control - Photocopy bluefile and create labels as per PPP D212-664-207 CHG003

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-207	Aft Crosstube - Low Standard	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
MS21920-28	Clamp	4 Ea (4 ea)	240-Crosstubes - 5 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D212-664-207 155965	①	0	0
240-Crosstubes - 5 - B4B	MS21920-28 5171291	④	146	0

See Next Page. ja

011294

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-207	Aft Crosstube - Low Standard	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5184886
MS21920-28	Clamp	4 Ea (4 ea)	240-Crosstubes - 5 - B4B	
AN6-40A	3/8-24 Bolt X 3" Long	4 Ea (4 ea)	255-Packaging 1-1 - Pick Kit - B4B	5133179
AN6-41A	Bolt	2 Ea (2 ea)	255-Packaging 1-1 - Pick Kit - B4B	5149318
D3428-1	Placard	1 pcs (1 ea)	255-Packaging 1-1 - Pick Kit - B4B	5112841
MS21042L6	Nut	6 Ea (6 ea)	255-Packaging 1-1 - Pick Kit - B4B	5182056
NAS1149D0663J	Washer	18 Ea (18 ea)	255-Packaging 1-1 - Pick Kit - B4B	5167625

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D212-664-207	1	2	0
240-Crosstubes - 5 - B4B	MS21920-28	4	114	0
255-Packaging 1-1 - Pick Kit - B4B	AN6-40A	4	65	0
	AN6-41A	2	37	0
	D3428-1	1	16	0
	MS21042L6	6	270	0
	NAS1149D0663J	18	648	0

Part Specifications

Specifications could not be found.

Plex 8/8/19 10:42 AM Dart.Renwick.Jennifer

PAGE 1 OF 1

Description: CROSSTUBE INSTALLATION, LOW AFT

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DAET a e r o s p a c e	
PATENT	N/A
P/N	D212-664-207
DESC.	Crostrube Std Aft
LOT	Bel-2041205121012121214UH-1
MODEL	B184886
TC APPROVAL # 09-89	
MADE IN CANADA	
CHG	CHG004
STC	SH01-9
STC	SR01298NY
1220 ABERDEEN ST. HAWKESBURY ON, CANADA K6A 1K1 TEL: 1-613-532-5200 www.hartaro.com	
D2729-A	

PAGE 1 OF 1

Description: CROSSTUBE INSTALLATION, LOW AFT

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

5.3 STANDARD GEAR CROSSTUBES

Item	QTY -107	QTY -207	QTY -209	Part Number	Description
	X			D212-664-107	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD FWD
		X		D212-664-207	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD AFT
			X	D412-664-209	CROSSTUBE INSTALLATION, 412 STANDARD AFT
6	1			D212-664-147	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD FWD
7		1		D212-664-247	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD AFT
8			1	D412-664-249	CROSSTUBE ASSEMBLY, 412 STANDARD AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
45	2			* D3659-1	CUFF
46		2	2	* D3660-1	CUFF
47	44	44		* CR3212-4-06	RIVET (M7885/3-4-06)
48			44	* CR3212-4-07	RIVET (M7885/3-4-07)
50	1	1		D3428-1	PLACARD

*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-147/-247 OR D412-664-249 ASSEMBLIES ABOVE

NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AAI SKIDTUBES.